

Work Order ID 69091

Friday, April 29, 2011 7:25:50 AM



Page 1

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/04/29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3874

Rev A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x1

Jh
11/05/03

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 2:00 am 11/05/03

Time OUT: 7:00 am 11/05/03

x1

Jh
11/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69091

Friday, April 29, 2011 7:25:50 AM

Page 2

Item ID: D3874-1

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Setup Start

Revision ID:

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Item Name: Floor Protector

Start Date: 4/29/2011 Start Qty: 1.00

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474
Dwg Rev: A
Folio Rev: A

x1

JH
11/05/03

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x1

JH
11/05/03

130

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8 11/05/03

(x1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69091

Friday, April 29, 2011 7:25:50 AM



Page 3

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	Memo	0.00				x1			Dh 11/05/04
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x1			Dh 11/05/04
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				5			11/05/04
Quality Control						CU			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69091

Friday, April 29, 2011 7:25:50 AM



Page 4

Item ID: D3874-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PRP
68079

0.00

Packaging

11/10/11 (1)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 (1)

R/11-05-4
(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 29, 2011 7:25:46 AM

Page 1

Work Order ID: 69091



Parent Item: D3874-1



Parent Item Name: Floor Protector

Start Date: 4/29/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.118-90318-08

Purchased

No

100

sf

2,225.084

4.38

4.38



Lexan Sheet

Location

therm

Loc Qty

2225.08472

2225.08472

Loc Code

H3127

4.38 sq ft

DL
11/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69091
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh

Date: 11/05/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.065"	✓		CAL TH-DT	
0.065	Min	0.095"	✓		CAL TH-DT	
0.5	Min	0.575"	✓		LI	

Measured by: Dh

Date: 11/05/04

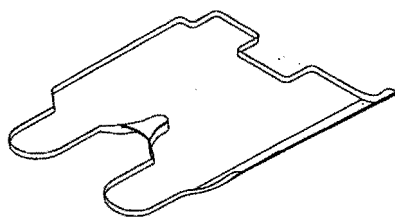
Audited by: S

Date: 11/05/04

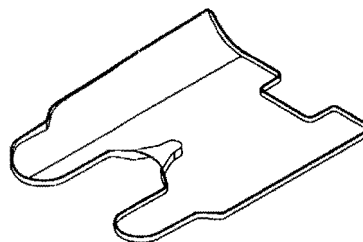
Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

CL11/04/29
W10'. 69091

RELEASED
29/05/05

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3874	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	FLOOR PROTECTOR	NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTROLLED BY THE SUPPLIER. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B

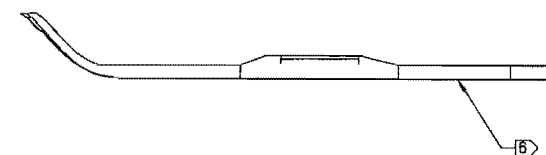
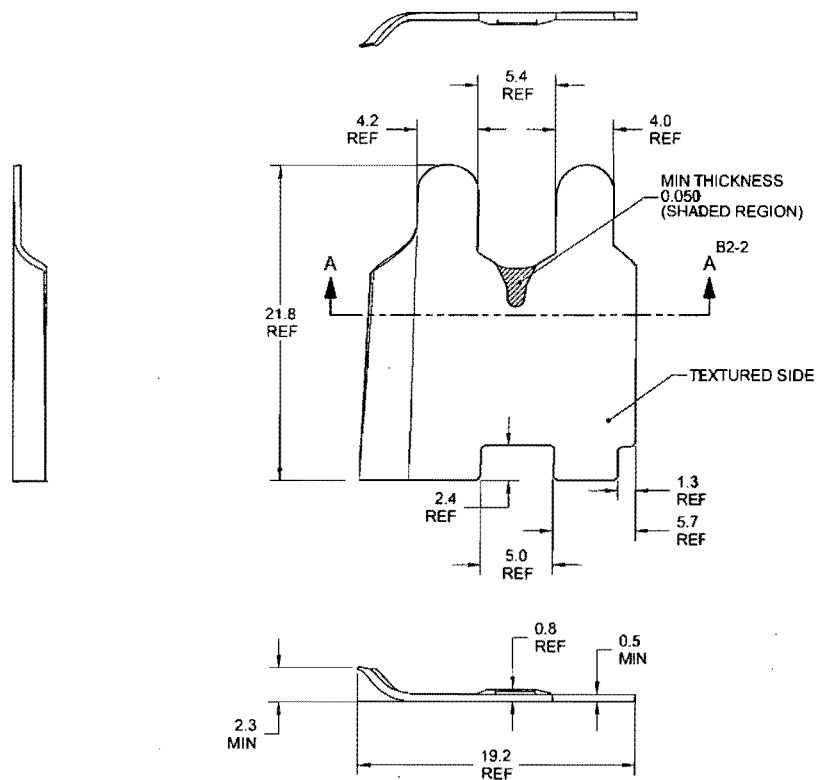
A

D

C

B

A



SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

NOTES:

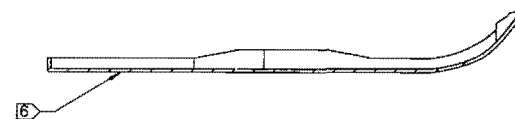
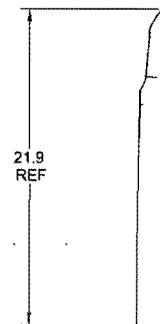
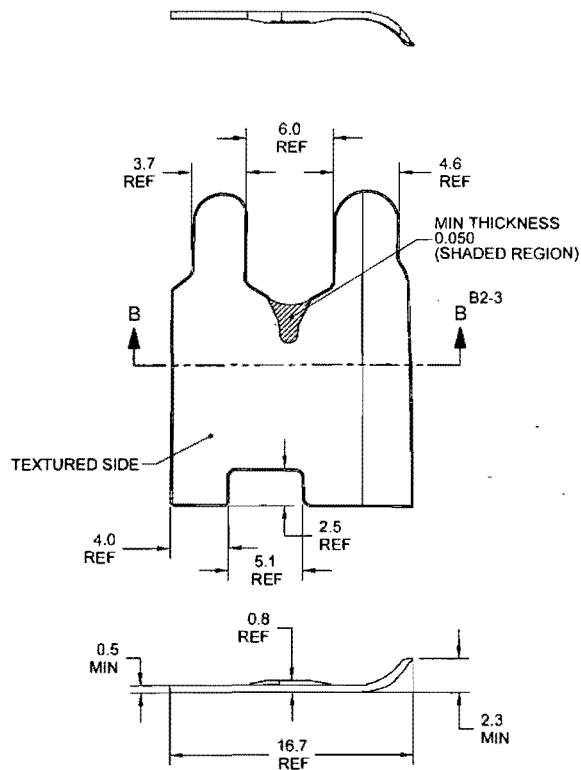
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

W/O. 69091

RELEASED
8/25/05/MD

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3874	REV. A
MFG. APPR.	PH	SHEET 2 OF 3	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	Per	DART AEROSPACE LTD	
DRAWN	Per	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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RELEASED
2/15/05

